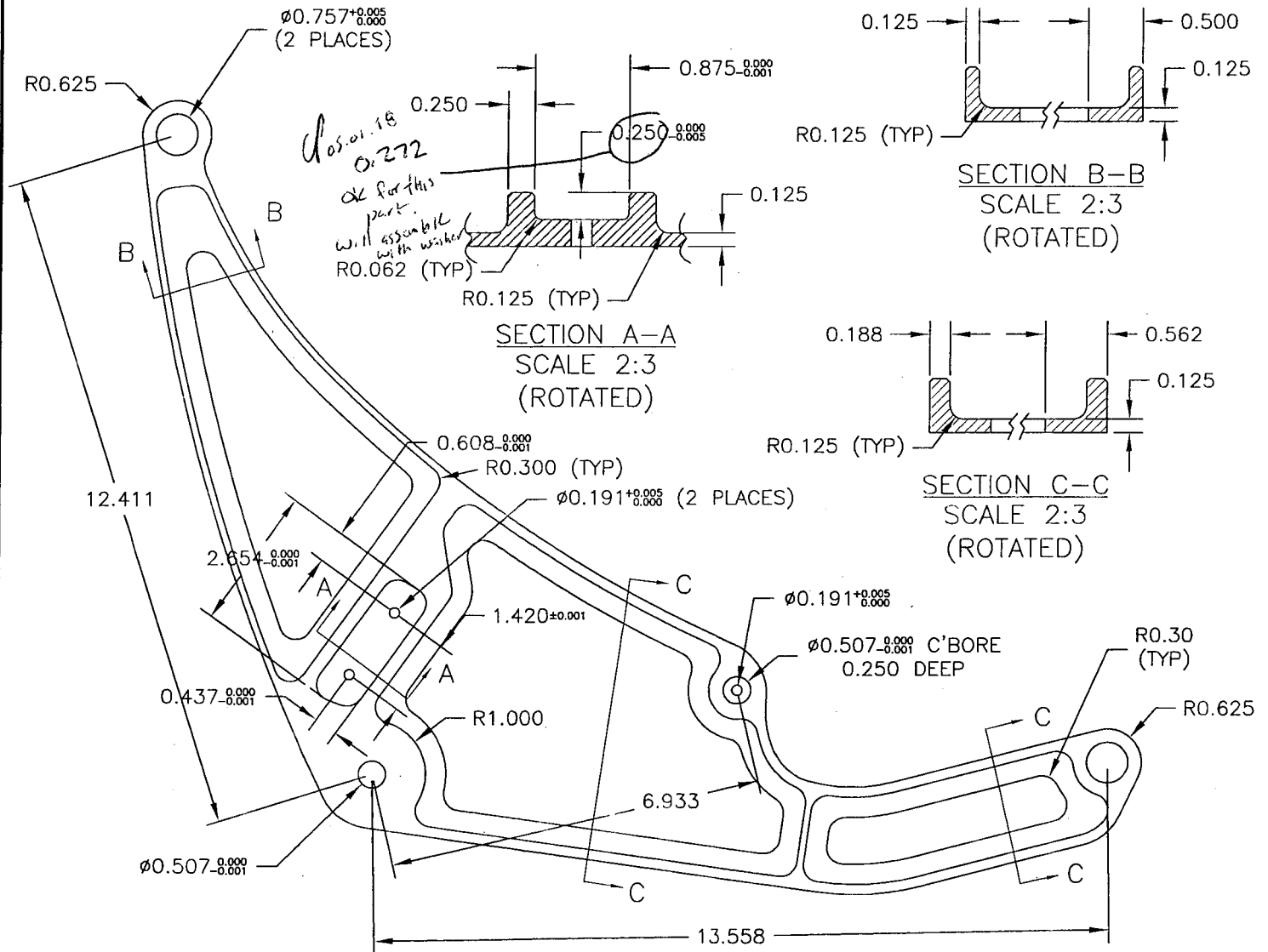


DART AEROSPACE LTD		Work Order: 22269
Description: D2804-1/-2, D2803-1/-2 Re-work.		Part Number: 22269 1/1
Dwg: D2803, D2804, Rev B.		Qty:
		Page of

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	ML	Pick:		05.01.17	
		Qty Part # Desc Batch			
		2 D2803-1 Bracket B14239			
		2 D2804-1 Bracket B14241		05.01.17	
		1 D2803-2 Bracket B14240			
		1 D2804-2 Bracket B2B05			
		Ensure to keep track of Batch #'s			
3	ML	MACHINE AS PER Rev B: D2803; D2804 Rev B.	ML	05.01.18	
4	QCS	Inspect Mark to Step #3.	QCS	05.01.18	
5	FP	Chemical Conversion Coat AS PER DART QSI QCS 4.1.	FP	05.01.18	
6	QCS	Inspect Chemical Conversion Coat	ML	05.01.19	
7	ST	Identify & Stock as Rev B. ^{stock only} D2804-1 B14241	CL	05.01.27	1
8	PC	Cost/Pack 164.48	SUC	05.01.28	
9	PC	Close info.	HA	05.01.31	
Rev	Date	Change	Revised By	Approved	
HA					

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS	



REFERENCE ONLY

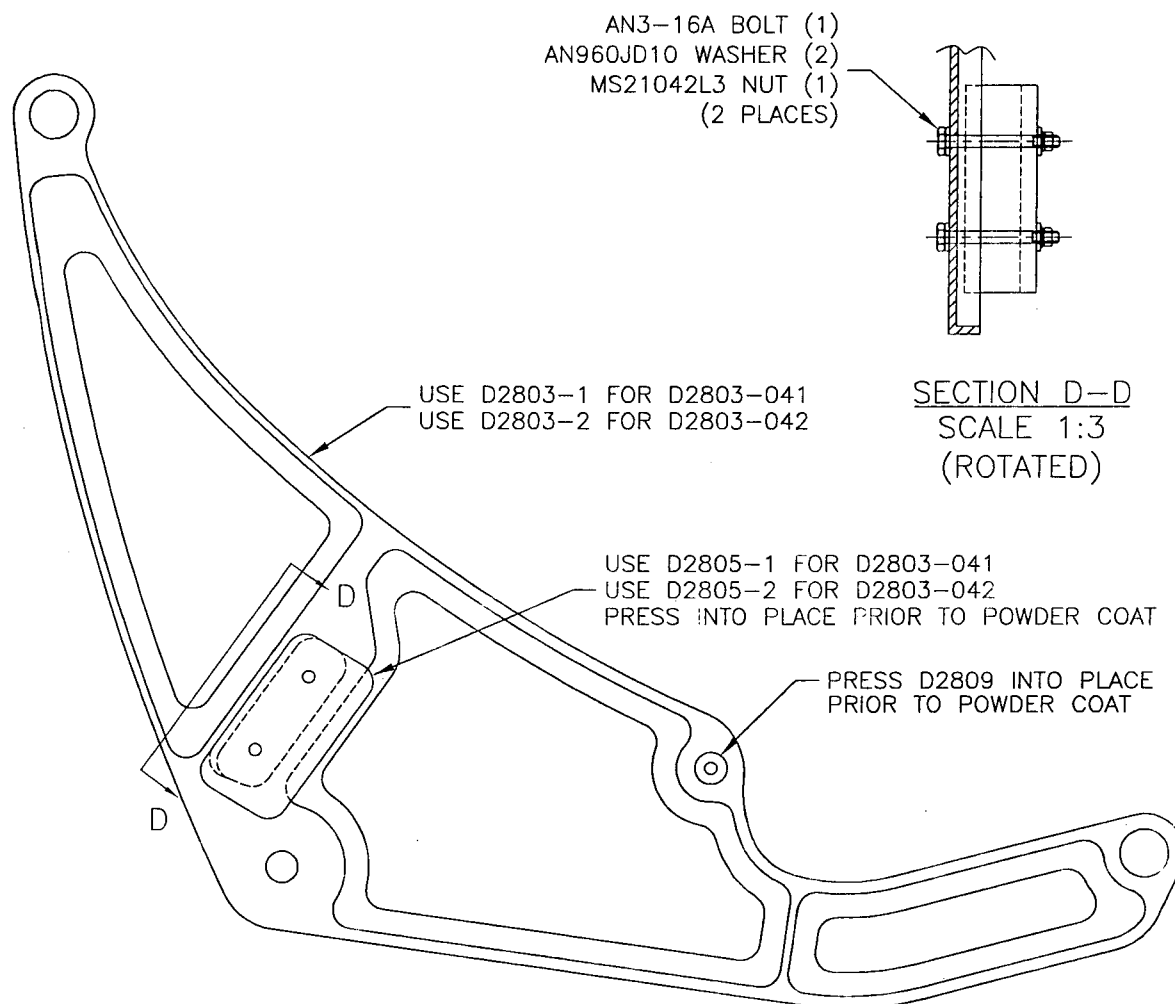
D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDprt"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



REFERENCE ONLY


D2803-041 BRACKET ASS'Y (SHOWN). D2803-042 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

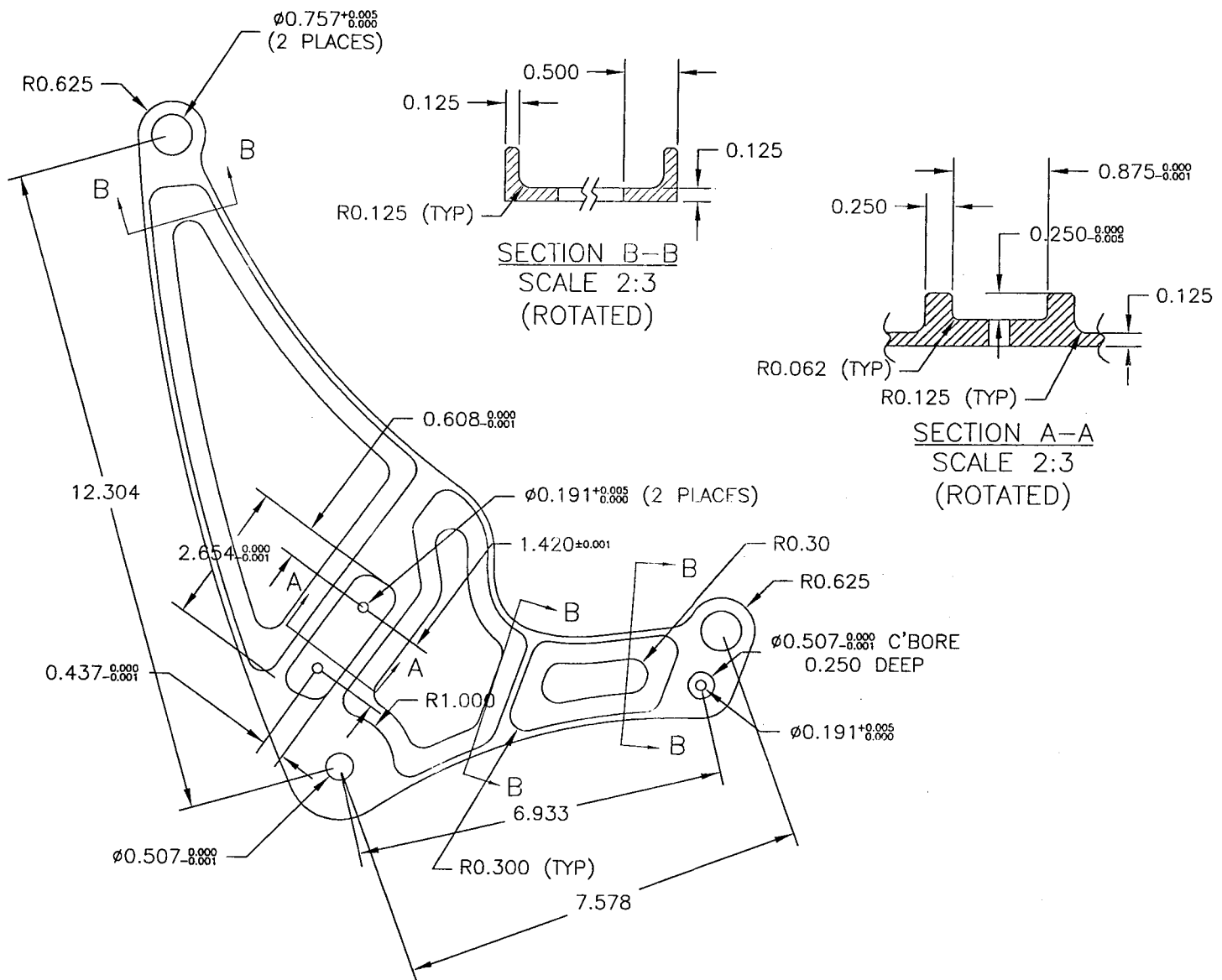
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PRELIMINARY ISSUE

DESIGN		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2804	
				REV. B SHEET 1 OF 2	
DATE 04.11.22			TITLE STA 155 BRACKET		
			SCALE 1:3		
A	00.11.07		NEW ISSUE		
B	04.11.22		NEW ISSUE		

REFERENCE ONLY



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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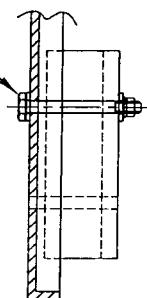
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PRELIMINARY ISSUE

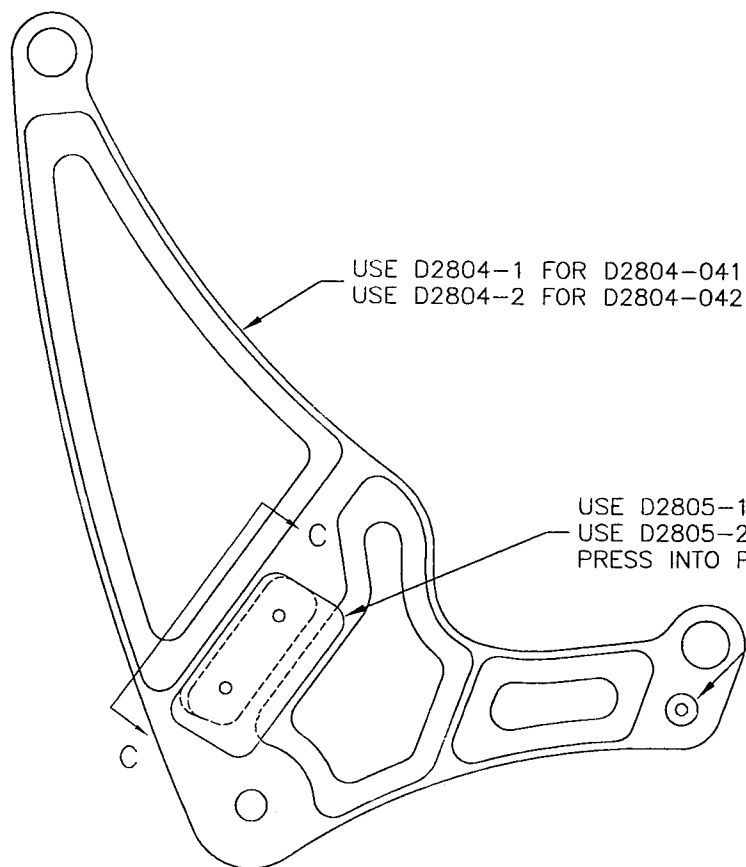
DESIGN	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3

REFERENCE ONLY

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

D2804-041 BRACKET ASS'Y (SHOWN). D2804-042 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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